

Date: Monday, 12/5/2005 9:25:27 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BAR
Job Number	: 25101		
Estimate Number	: 10390		
P.O. Number	: N/A	Part Number	: D3197041
This Issue	: 12/5/2005	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3197 REV A1
First Issue	: 12/5/2005	Project Number	: N/A
Previous Run	: 24132	Drawing Revision	: A1
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 12/20/2005
Checked & Approved By	: <u>See comment below</u>	Qty:	20
Comment	: Est Rev: A New Issue 05-11-08 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M7075T73R1000	7075-T73 Round Bar 1" OD
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Comment: Qty.: 2.5410 f(s)/Unit Total: 50.8200 f(s)
 Material: 7075-T73 (QQ-A-200/11) or (QQ-A-225/9) 1" OD
 (M7075T73R1.000) *145.5'*
 Identify for D3197-1 *M18600*
 Batch: *M19052 437'*

ml 05/12/06 20

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 29.125" long

ml 05/12/06 20

<i>5.0b</i>	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE
~~Turn To Length and~~ Chamfers as per Dwg D3197

ml 05/12/10 20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 05/12/10 20

<i>5.0A</i>	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
1-face ends to length per Dwg D3197
2-Machine D3197-1 as per Folio FA340 and Dwg D3197

3-Deburr

EP 05/12/07 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/5/2005 9:25:36 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 25101

Part Number: D3197041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ED 05/12/07 20

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 05/12/10 20

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 1 02/11/05 1 20

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

ml 05/12/03/ 20

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

D26905

Lanyard ass'y



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 D2690-5

Lanyard

1324959
B25104

12.0

D32421

Tag



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 D32421

Tag

B25105

DL 05/10/04

13.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick:

Qty Part Number

Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/5/2005 9:25:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 25101

Part Number: D3197041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12 AN960JD10

Washer ~~115819~~ M 19413

14.0

DARS004

Pip Pin



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 DARS-004

Pip Pin

M19048x6, M19439x4, M19440x30

DL

15.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 MS21042L3

Nut (or -3)

M17632

16.0

MS27039124

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 MS27039-1-24 Screw

M3283

M19391

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3197-041 as per Dwg D3197

DL 06/06/04 20

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206-01-05 20

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

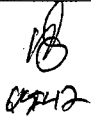


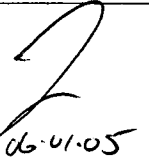
Location: 94

10 06/01/05

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 06/01/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-05	17	Wrong washers were installed.		Remove AN960-10 and replace with AN9603D-10 as per Dwg.	SB 06/01/05	 06-01-05		 06-01-05

NOTE: Date & initial all entries

Date: Monday, 12/5/2005 9:25:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 25101

Part Number: D3197041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

546 06/01/06

(20)

DD

06/01/06

(28)

Job Completion



J

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

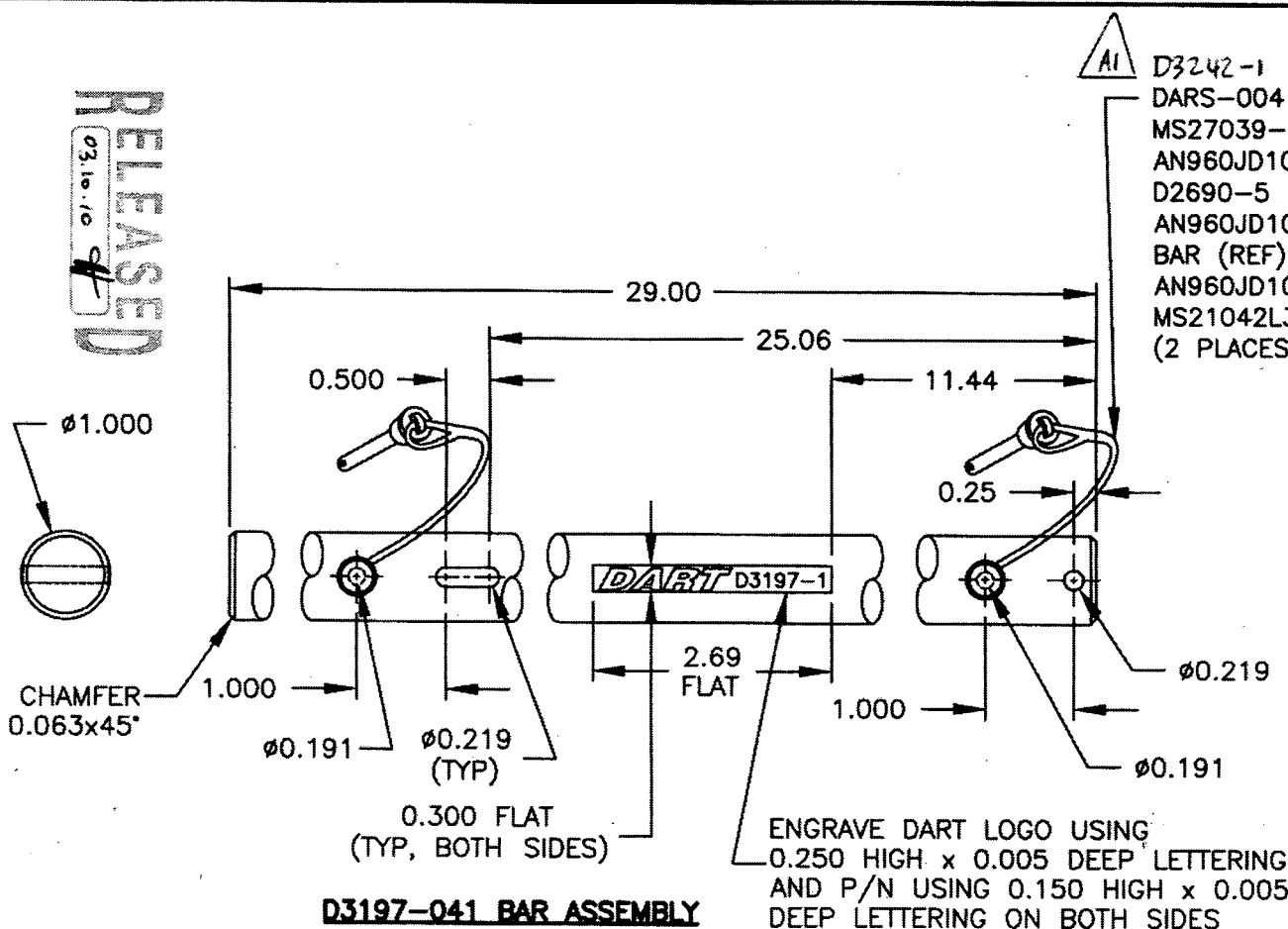
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
03.10.10



D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) $\phi 1.000$ O.D. (REF DART SPEC. M7075T73R1.000)
- 2) POSSIBLE SUPPLIER FOR DARS-004 PIP PIN: REID TOOL SUPPLY. IT IS ACCEPTABLE TO REPLACE WITH ANY STAINLESS STEEL DOUBLE-ACTING QUICK-RELEASE PIN WITH A $\phi 0.188$ DIAMETER PIN, 1.8"-2.0" GRIP LENGTH, MIN. OF 200 lbs PULL-OUT STRENGTH, AND MIN. OF 5150 lbs DOUBLE SHEAR.
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
03.07.01	D3197	SHEET 1 OF 1
A	03.07.01	SCALE
A1	04.01.12	1:1
	ADD D3242-1 TAG	
	NEW ISSUE	
	BAR	